

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021081**Date Inspected:** 25-Feb-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC) Chanxing Island **Location:** Shanghai, China

CWI Name:	Mr.			CWI Present:	Yes	No	
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A

Bridge No: 34-0006**Component:** OBG Segment**Summary of Items Observed:**

On this date CALTRANS OSM Quality Assurance (QA) Inspector Santhosh Ramakrishna Pillai was present during the times noted above for observations relative to fabrication work of the Self Anchored Suspension (SAS) Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China.

This QA inspector randomly observed the following work:

1. INPROCESS:

Orthotropic Box Girder (OBG) at Trial Assembly Area:

ZPMC welding personnel performing Shielded Metal Arc Welding of Repair weld for the edge plate to deck plate hold back weld joint located on 12BE+12CE at bike path side. The weld is designated as CA3003-006(12BE) & CA3005-002(12CE). The welder is identified as 044504. ZPMC QC Mr. WANG ZHU was onsite monitoring the welding variables. The inprocess Shielded Metal Arc Welding appears to be progressing in compliance with WPS-345-SMAW-2G (2F)-FCM-Repair-1. The weld repair report number is named as CWR-2808.

ZPMC welding personnel performing Shielded Metal Arc Welding of Fillet welds joining the side plate to I-stiffener weld joint located on 12AE+CB-17 at Panel Point (PP-110). The weld is designated as SP3026-017-133. The welder is identified as 066459. ZPMC QC Mr. LI YANG was onsite monitoring the welding variables. The

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inprocess Shielded Metal Arc Welding appears to be progressing in compliance with WPS-B-P-2112-FCM-1.

ZPMC welding personnel performing Flux Core Arc Welding of Fillet welds joining the floor beam to bottom plate weld joint located on 12AW+CB-17 at Panel Point (PP-111). The weld is designated as CB3001A-017-010. The welder is identified as 047353. ZPMC QC Mr. LI YANG was onsite monitoring the welding variables. The inprocess Flux Core Arc Welding appears to be progressing in compliance with WPS-B-T-2132-ESAB.

ZPMC welding personnel performing Flux Core Arc Welding of Fillet welds joining the floor beam to bottom plate weld joint located on 12AE+CB-17 at Panel Point (PP-111). The weld is designated as CB3001A-017-012. The welder is identified as 040367. ZPMC QC Mr. LI YANG was onsite monitoring the welding variables. The inprocess Flux Core Arc Welding appears to be progressing in compliance with WPS-B-T-2132-ESAB. Further weld detail mention in attached picture.

ZPMC welding personnel performing Shielded Metal Arc Welding of Fillet welds joining the side plate to I-stiffener weld joint located on 12AE+CB-17 at Panel Point (PP-112). The weld is designated as SP3032-017-031. The welder is identified as 044504. ZPMC QC Mr. LI YANG was onsite monitoring the welding variables. The inprocess Shielded Metal Arc Welding appears to be progressing in compliance with WPS-B-P-2114-FCM-1.

ABF Quality Assurance (QA) personnel performing Ultrasonic Testing (UT) for the side plate to side plate transverse splice weld joint located on 12BW+12CW at cross beam side. The weld is designated as OBW12E-002.

ABF Quality Assurance (QA) personnel performing Ultrasonic Testing (UT) for the side plate to side plate transverse splice weld joint located on 12BE+12CE at bike path side. The weld is designated as OBE12E-003.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

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No relevant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Pillai,Santosh
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Quality Assurance Inspector

Reviewed By:	Miller,Mark
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QA Reviewer
